



Superbond

MILD STEEL GENERAL PURPOSE (MSGP)



Mild Steel Electrode for General Purpose Welding

CLASSIFICATION :	AWS A/ SFA 5.1	IS 814	APPROVALS :
	E 6013	ER 4212X	ABS/BV/DNV/IRS/LRA/IBR/BIS/NKK/MND

KEY FEATURES :

- Rutile coated
- Suitable for general purpose structural steels
- All position operating characteristics
- X-ray quality weld deposit

WELDING POSITION :   AC (50 OCVmin.)/ DCEN

TYPICAL APPLICATIONS :

- Steel structures
- Tanks
- Truck frames and bodies
- Ships, Pipelines
- Bridges
- Joining ASTM SA 283 Gr.A/B/C/D

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	S	P
Typical	0.07	0.5	0.2	0.02	0.02
Specification	0.10 max	0.60 max	0.30 max.	0.03 max.	0.03 max.

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS, MPa	EL%	CVN Impact at 0°C, J
Typical	As Welded	500	430	25	60
Specification		460-550	370-480	22-28	50 min.

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs/Carton	Carton/Box	Approx. wt. of 1000 pcs, Kg.
2.5 x 350	60-90	296	4	17
3.15 x 350	100-130	171	4	29
3.15 x 450	100-130	139	4	36
4.0 x 450	140-180	90	4	55
5.0 x 450	180-240	58	4	85